

Work Order ID 75383

75383

Page 1

October-21-11 11:28:42 AM

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 21/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/21

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3804	A								
IIN-D206-642	O								

100
100

DC
Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-151

0.00

0.00

CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804								
	3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.								
	Pick:								
	Qty Part Number Description Batch								
	A/R Aluminum Rod <i>m118735/m117889</i>								
	4-Grind weld flush to cap on top surface only.								
	5-Cut Aft end as per dwg D3804 from front of tube and Deburr								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804								
	7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt8166 & DT8169D & DT9771.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time:								

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.								
	12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804								
	13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder								
	14-Remove indexing edge using DT8741 as per Dwg D3804								
	15-C'sink GHW rivet holes as per Dwg D3804								
	16- Open Aft cap hole #6. ****no wearplate holes for this skidtube****								
	17-Deburr tube and blow out chips from inside the tube								

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

Sululzy

De
11/11/24

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		OK 11/11/24					
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		SAD 11-11-24		①			
160 *160* Skidtubes Skidtubes	Skidtubes Memo 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) 3-Deburr and blow out all chips from inside the tube	0.00 0.00		OK 11/11/24					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 02/11/2011 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC6- Inspect dimensions to drawing

0.00

170

QC

Memo

0.00

Quality Control

1 0 BE11-11-24

180

Skidtubes

0.00

180

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: 11/11/24 Time: 6:35

Finish Date: 11-11-28 Time: 8:00

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 119399

Sikaflex expire date: 12/08/13

11/11/24

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*** 1 ***

Required Date: 02/11/2011 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 of BF 11-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

Skidtubes

0.00

Memo

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch
A/RAluminum Rod **M117889**

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod **NONE** **BB 11-11-29**

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BB 11-11-28

BB 11/11/29

DP 11-11-30

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210		0.00							
210	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	Install D2680-041 Nut Plate as per Dwg D3804								
215		0.00							
215	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									
220		0.00							
220	QC10- Inspect visual per QSI004- ground welds								
QC	Memo	0.00							
Quality Control									

(Handwritten signature and date 11.11.30)

(Handwritten signature and date 11.11.30)

(Handwritten signature and date 11.11.30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Required Date: 02/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<i>11.12.01</i>
240 *240* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							<i>11/12/01</i>
250 *250* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							<i>11/12/05</i>

START TIME: *8-30*
 OVEN TEMPERATURE: *320*
 FINISH TIME: *9-00*

MU8434

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260						164	6	11/12/12	
QC	Memo	0.00							
Quality Control									
270		0.00							
270	HandFinishing					164	6	11/12/12	
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

LH

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Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	HandFinishing	0.00							
280									
HandFinish	Memo	0.00							
Hand Finishing	✓ 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>11118443</u> Sikaflex expire date: <u>12/01</u> 2- Install wearplate as per dwg 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: <u>11118900</u>								
290	QC3- Inspect Part Finish	0.00							
290									
QC	Memo	0.00							
Quality Control									

1 WH 6 11/12/11

6 11/12/13

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300	QC5- Inspect part completeness to step on W/O	0.00							
300									
QC	Memo	0.00							
Quality Control									
310	Packaging	0.00							
310									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-151								
	Location: _____								
	PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

Summary

PPP 75716

11/2/12

11/12/14

11-12-14

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC IPP
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	13.0000	1	1			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2620

Skidtube, 206 Skidtube

**

De 11/11/24
1

Location

Loc Qty

Loc Code

LG

74461

13

71616

3

71617

6

73783

1

73785

1

73786

2

D2647

Manufactured No

110

Each

199.0000

1

1

D2647

Cap

**

BB 11-11-24

Location

Loc Qty

Loc Code

LG002

199

55352

4

71171

11

73826

184

1

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

18,966.00

52

52

CR3212-4-04

Cherry Rivet

Location

Loc Qty

Loc Code

ST311

150

52

116471

78

117816

3

118686

1

118840

68

st510

10000

119075

10000

ST516

8816

119017

8816

D2654-1

Manufactured

No

180

Each

4.0000

1

1

D2654-1

Web

Location

75476

Loc Qty

Loc Code

LG

4

73794

4

D3286-1

Manufactured

No

180

Each

110.0000

2

2

D3286-1

Doubler

Location

19872

Loc Qty

Loc Code

LG002

110

74111

22

74441

88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-21-11 11:28:47 AM

Page 3

Work Order ID: 75383

75383

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 200 Each 1,184.000 19 19

D2649

Cross Bolt Spacer

**

BE 11-11-28
B73859 x19

Location	Loc Qty	Loc Code
LG	617	
68224	2	
71355	2	
72704	2	
72841	11	
73855	600	
LG001	567	
65317	1	
68507	11	
73390	8	
73857	21	
73860	526	

D3286-3 Manufactured No 200 Each 101.0000 2 2

D3286-3

Spacer

**

BE 11-11-29
B74870 x2

Location	Loc Qty	Loc Code
LG001	101	
74117	21	
74439	80	

D2680-041 Manufactured No 210 Each 99.0000 1 1

D2680-041

Nut Plate

**

11/11/30

Location	Loc Qty	Loc Code
LG	4	
73334	4	
ST020	95	
73854	95	

October-21-11 11:28:47 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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October-21-11 11:28:47 AM

Page 4

Work Order ID: 75383

75383

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

2,010.000

2

CR3212-4-03

Cherry Rivet

**

2 11/11/11

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1008

114859

1008

ST318

1000

119017

1000

AN960JD416

NAS1149D0463L

Purchased

No

210

Each

0.0000

1

AN960JD416

Washer

**

1 11/12/12 (x1) M118384

CCR264SS3-3

Purchased

No

210

Each

1,285.000

2

CCR264SS3-3

Cherry Rivet

**

2 11/11/11

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

283

117849

283

ST317

1000

119017

1000

MS27039-4-06

Purchased

No

210

Each

433.0000

1

MS27039-4-06

Screw

**

1 11/12/12

Location

Loc Qty

Loc Code

ST292

433

119075

400

119124

33

VI

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October-21-11 11:28:47 AM

Work Order ID: 75383

75383

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No

270 Each 1,063.000 6 6

D2651-1

Plug

**

Handwritten: 11/12/12

Location	Loc Qty	Loc Code
fpa	2	
69018	2	
FP-A	1061	
57869	1	
66445	10	
70839	2	
71037	31	
73827	1017	

Handwritten: X6

D2651-3 Manufactured No

270 Each 1,547.000 6 6

D2651-3

O-Ring

**

Handwritten: 11/12/12

Location	Loc Qty	Loc Code
FP-A	1547	
61962	12	
66956	30	
73489	505	
73828	1000	

Handwritten: X6

D3873-1 Manufactured No

280 Each 342.0000 14 14

D3873-1

Bushing

**

Handwritten: 1373832 (x14) 11/12/12

Location	Loc Qty	Loc Code
ST088	342	
64760	1	
68247	4	
73829	19	
73831	318	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 75383

75383

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

91.0000

1

1

D2646

Aft Cap

**

B73825 (x1) Hl ul/ul/2

Location

Loc Qty

Loc Code

FP002

60

73294

60

FP004

17

68280

17

FP006

5

62678

5

FP-4

5

70945

1

71070

4

fp5

4

71038

4

D3805-041

Manufactured No

280

Each

0.0000

1

1

D3805-041

Wearplate Assembly Fwd, Low Gear

MS27039-1-08

Purchased No

280

Each

1,971.000

2

2

MS27039-1-08

Screw

**

B76362 (x1) Hl ul/ul/2

**

Hl ul/ul/2

Location

Loc Qty

Loc Code

ST291

1971

117423

155

118378

316

118910

500

119075

500

119109

500

v2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75383

75383

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

280

Each

9,976.000

7

7

**

Handwritten: 11/12/12

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

976

117441

16

117885

87

118451

179

118927

694

ST516

6000

119017

6000

ST518

3000

119075

3000

Handwritten: x 7

D3805-045

Manufactured

No

280

Each

5.0000

1

1

**

Handwritten: 1375494 (x1) 11/12/12

D3805-045

Wearplate Assembly Aft, Low Gear

Location

Loc Qty

Loc Code

FP

5

73817

5

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

**

Handwritten: 1118389 (x2) 11/12/12

AN960JD10L

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75383

75383

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A

Purchased

No

280

Each

2,319.000

7

7

AN3-37A

Bolt

**

del 11/12/12

Location

Loc Qty

Loc Code

ST353

269

111668

169

118628

100

ST354

50

117619

50

ST518

2000

119086

2000

x7

NAS1149D0363J

Purchased

No

280

Each

2,836.000

7

7

NAS1149D0363.I

Washer

**

del 11/12/12

Location

Loc Qty

Loc Code

ST298

2836

117601

218

118077

135

118612

483

118968

2000

x7

W/O:		WORK ORDER CHANGES					
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ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR284SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75383 M.C.U

11/10/21

RELEASED
08.07.07
per ECR 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.07		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. **D3804** REV. **A**
SHEET 1 OF 5

TITLE **SKIDTUBE ASSEMBLY, 206A/B** SCALE **NTS**

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Q 09.03.03



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CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 2 OF 2
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NT
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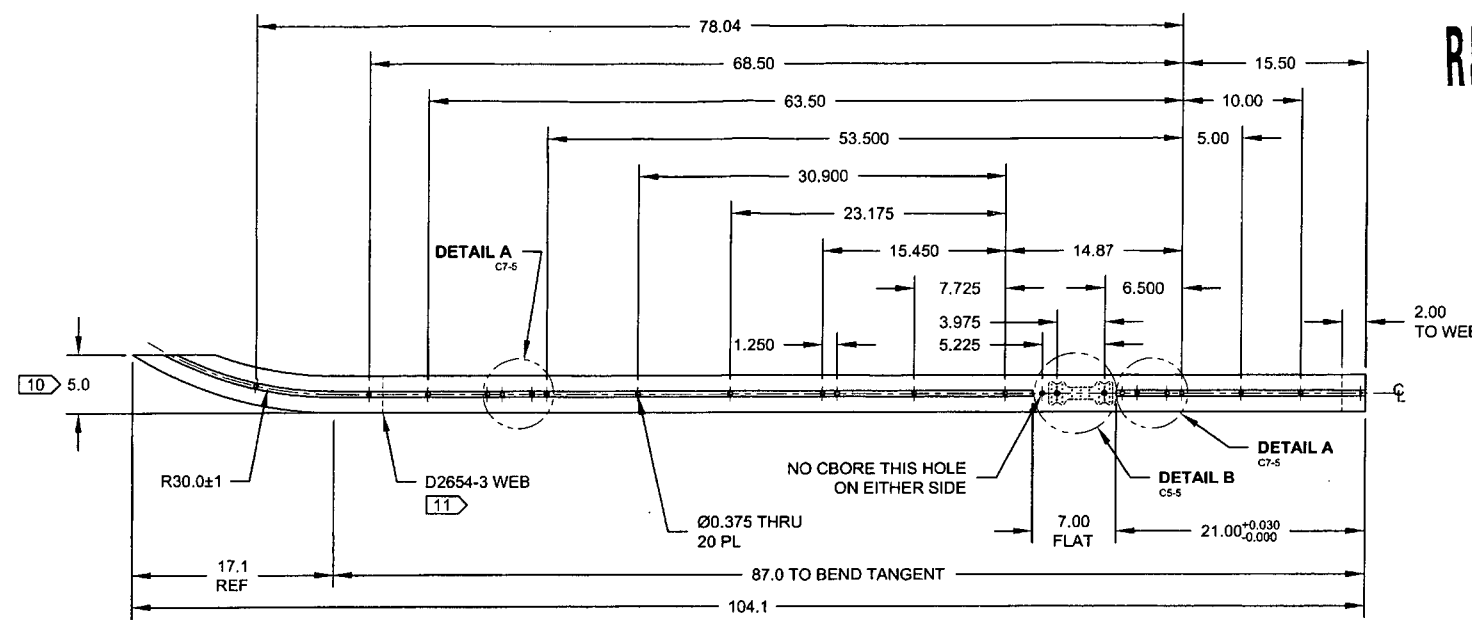
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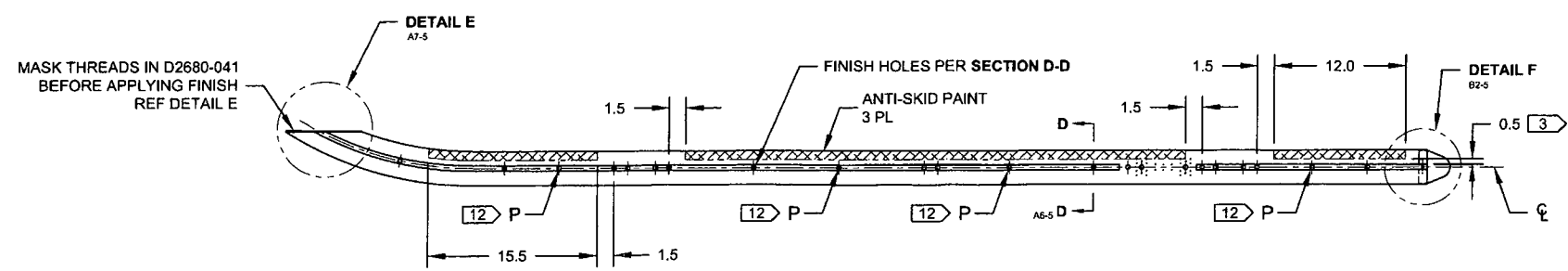
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09.03.03



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 3 OF 5
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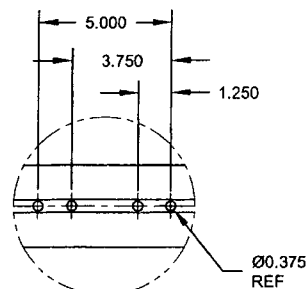
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

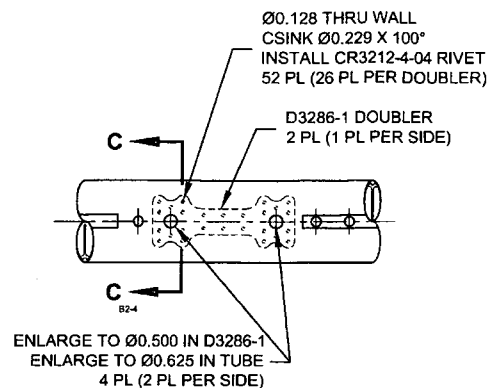
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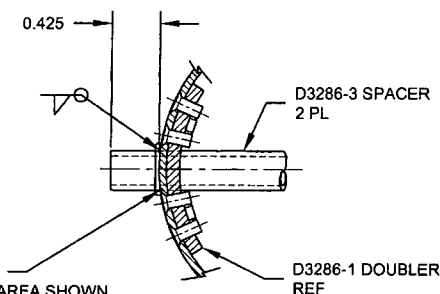
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09.03.03

DETAIL A
D6-2
C2-2
D6-3
C2-3
SCALE NONE

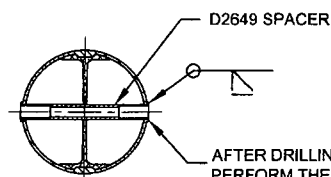


DETAIL B
C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
C6-4
PARTIAL SECTION
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	Q	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 4 OF 5
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NOTE: Date & initial all entries

75383

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09 09 03 03

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G
SCALE NONE A7-5

D2647 CAP. TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE
IN PLACE

MS27039-4-06 SCREW
AN960JD416 WASHER

D2680-041
NUTPLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

DETAIL E
SCALE NONE B7-2
B7-3

0.400

END OF WEB

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

DETAIL F
SCALE NONE B2-2
B2-3

DESIGN	01	DART AEROSPACE USA, INC	
DRAWN	01	PORT HADLOCK, WA	
CHECKED	01	DRAWING NO.	REV. A
MFG. APPR.	01	D3804	SHEET 5 OF 5
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries